

Work Order ID 96266

January-21-13 2:57:41 PM

96266

Page 1

Item ID: D3874-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector

Stop

NS2Start Date: 1/21/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan: <u>ML5</u>	Date: <u>13-01-21</u>	Tooling:	Date:	Run	Start	*NR1*
QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
X /									
DAS	07	0.89							
13/01/22									

105 Dry Material 0.00

105

HandThermo

Hand Finishing Thermoforming

Memo 0.00

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°FTime IN: 7:00 pm 13/01/21Time OUT: 7:00 am 13/01/22(DAS)
07
0.89

13/01/22

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Item ID: D3874-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector

Stop *NS2*

Start Date: 1/21/13

Start Qty: 1.00

1

Cust Item ID

Required Date: 2/04/13

Req'd Qty: 1.00

三

Customer:

Reference:

Approvals: Process Plan

Date:

Tooling

Data

Run Start

NP1

95

Date:

SPC (Y/N)

B-4

Step

NRT
ナニワ

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00			x1				DAS 07 13/01/22
140 *140* HandThermo	Memo 1-Trim to finished dimensions as per Dwg	0.00			x1				Sh 13/01/23
150 *150* QC	QC2- Inspect parts off machine FAI/FAIB Memo Complete FAI document	0.00			x1				Sh 13/01/23

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Item ID: D3874-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Floor Protector

Stop

NS2

Start Date: 1/21/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 15 13-1-23			J			

170 *170* Packaging Packaging	Identify as per dwg & Stock Location RT/S Memo	0.00 0.00							
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180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
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14 SP
13-01-24

13/1/25/10

13-01-24

Picklist Print

January-21-13 2:57:44 PM

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Work Order ID: 96266

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D3874-2

Parent Item: D3874-2

Parent Item Name: Floor Protector

Start Date: 1/21/13

Required Date: 2/04/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	753.4949	4.38	4.38			**

MI FXS 118-90318-08

Lexan Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
therm	753.4949406	
113127	753.494941	

Dh
13/01/23

4.38 sq ft.
0

DART AEROSPACE LTD	Work Order:	96266
Description: Floor Protector	Part Number:	D3874-2
Inspection Dwg: D3874	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{3}{16}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *Jh.*

Date: 13/01/22.

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.056"	✓			
0.065	Min	0.079"	✓			
0.5	Min	0.53"	✓			
21.9	REF	21.9"	✓			

Measured by: *Jh.*

Date: 13/01/23

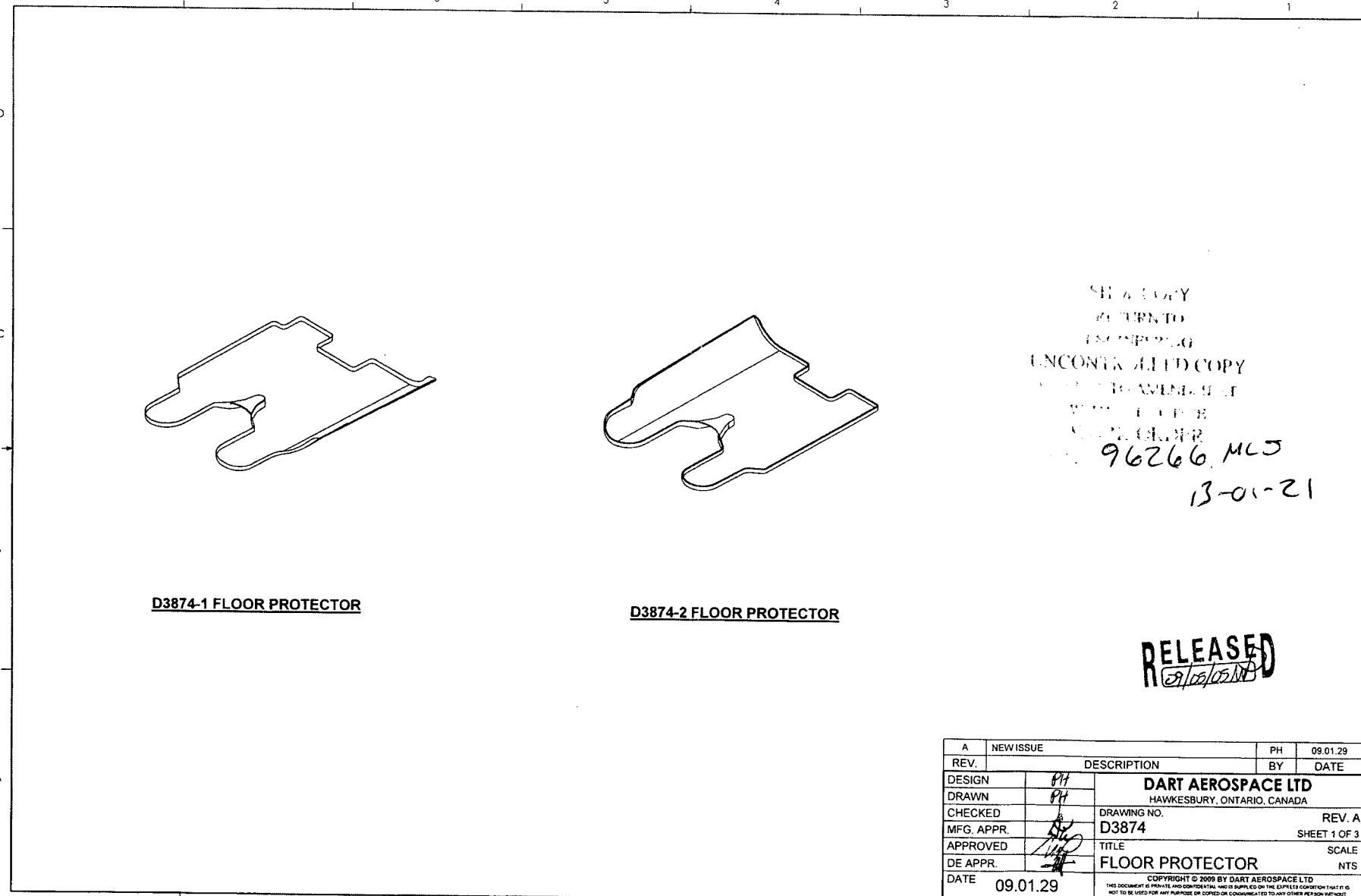
Audited by: *AS*

Date: 13-1-23

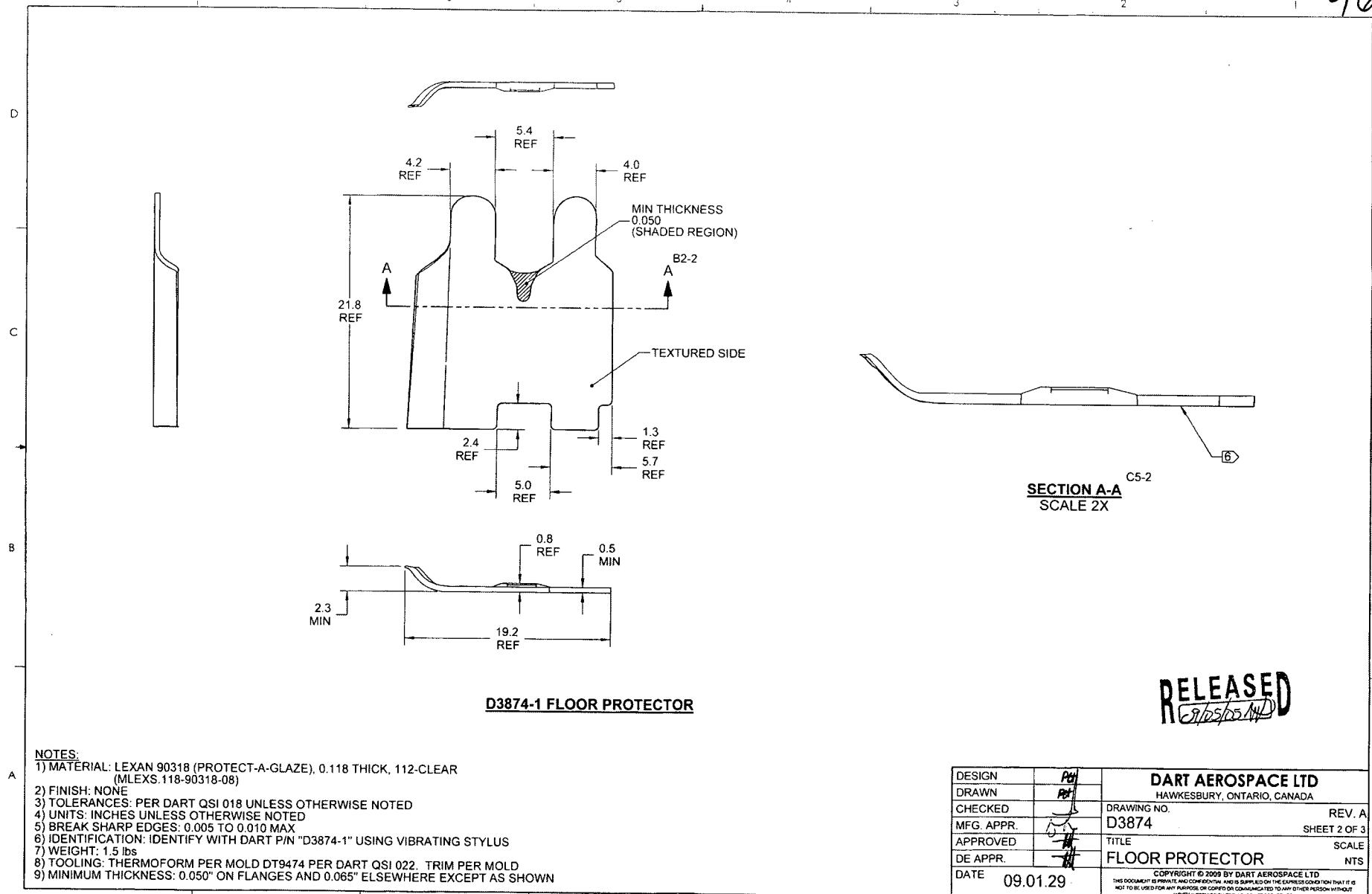
Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>JF</i>



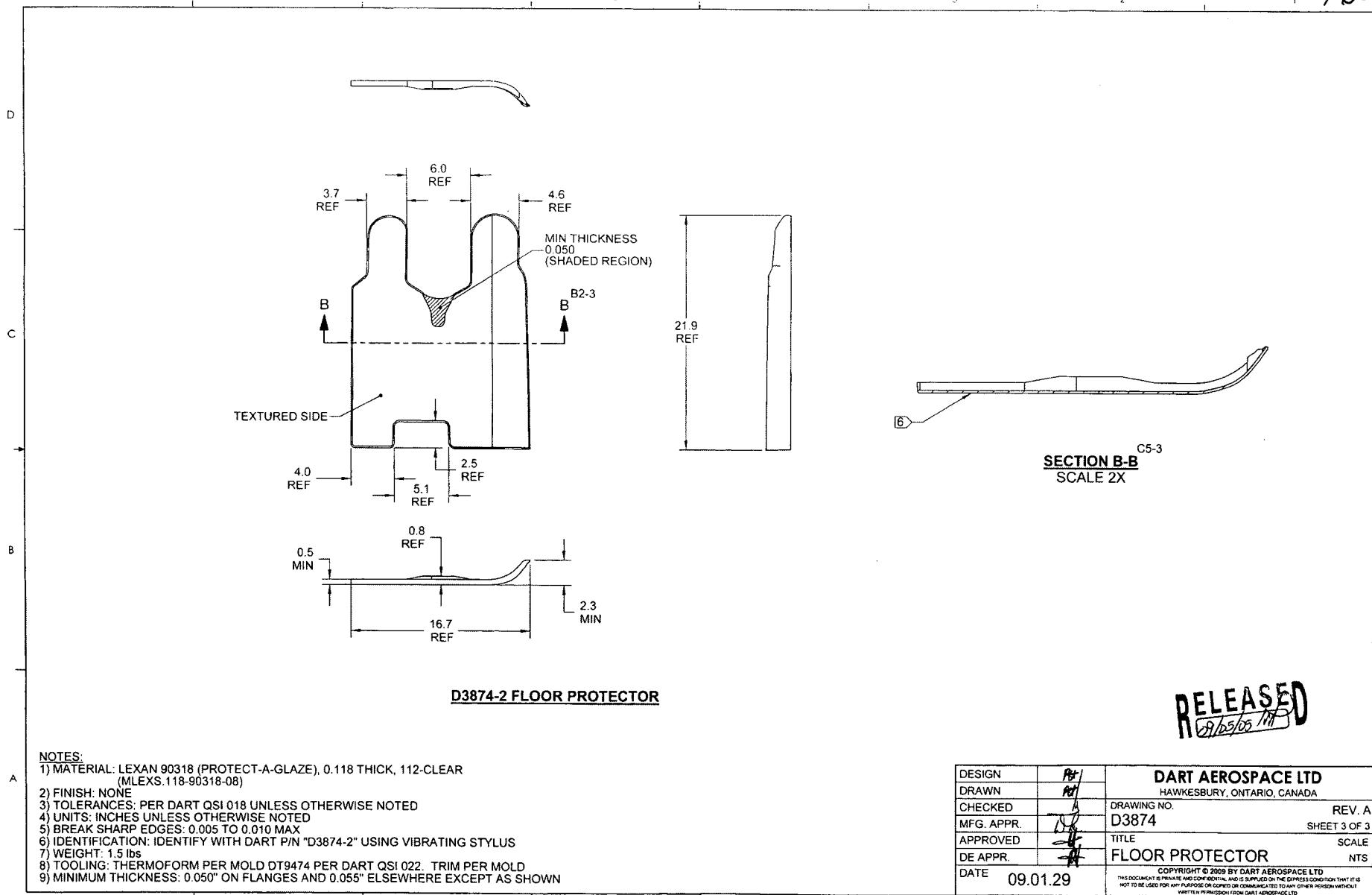
96266



DESIGN	P&J	DART AEROSPACE LTD
DRAWN	P&J	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3874
DE APPR.		SHEET 2 OF 3
DATE	09.01.29	TITLE
		SCALE
		NTS
		FLOOR PROTECTOR
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07/05/05 AM

96266



DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	REV. A
MFG. APPR.	<i>AB</i>	DRAWING NO. D3874
APPROVED	<i>AB</i>	REV. A SHEET 3 OF 3
DE APPR.	<i>AB</i>	TITLE FLOOR PROTECTOR
DATE	09.01.29	SCALE NTS

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